



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2435

Job Sheet 173352-A



Part No: D2435

Job Qty: 6 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/27/18

Job Tracking No:

Due Date: 3/12/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV E1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
120	Waterjet	6 pcs		3/9/18	0.00	1.12	Waterjet 2 OMAX	52	
130	CNC Vertical Machining	6 pcs		3/12/18	0.41	6.09	HAAS 1	9-89	18-03-28
150	QC	6 pcs		3/12/18	0.00	0.00	QC8		18-03-28
151	Packaging	6 pcs		3/12/18	0.00	0.00	Packaging3	SKY44 MAR 28 2018	04s
190	QC21-SA	6 Ea		3/12/18	0.00	0.00	QC21		6

Part Op 120 - CUT BLANK AS PER FILE D2435

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435

DAS
21
9-80
MAR 29 2018

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.063Inches + 0.030 - 0.010	0.093 0.053	0.063	
2	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	Angle 45°	
3	Bearpaw	5.500Inches ± 0.030	5.530 5.470	5.50	
4	Bearpaw	0.200Inches ± 0.030	0.230 0.170	0.195	
5	Bearpaw	0.250Inches ± 0.010	0.260 0.240	Radius -255	
6	Bearpaw	0.250Inches ± 0.030	0.280 0.220	25 Radius	
7	Bearpaw	0.625Inches ± 0.030	0.655 0.595	0.63	
8	Bearpaw	0.250Inches ± 0.010	0.260	0.250	

			0.240	
9	Bearpaw	45.000Degrees ± 0.000	45.000 45.000	45° Angle
10	Bearpaw	0.375Inches ± 0.010	0.385 0.365	.380
11	Bearpaw	19.000Inches ± 0.030	19.030 18.970	19.000
12	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940	.958
13	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	.260 Diameter
14	Bearpaw	0.930Inches ± 0.030	0.960 0.900	Diameter .930
15	Bearpaw	0.300Inches + 0.030 - 0.000	0.330 0.300	.310
16	Bearpaw	0.375Inches ± 0.030	0.405 0.345	.378
17	Bearpaw	7.375Inches ± 0.030	7.405 7.345	7.375
18	Bearpaw	4.250Inches ± 0.010	4.260 4.240	4.250
19	Bearpaw	2.000Inches ± 0.030	2.030 1.970	2.000
20	Bearpaw	9.000Inches ± 0.010	9.010 8.990	9.000
21	Bearpaw	15.750Inches ± 0.030	15.780 15.720	15.750

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DART
AEROSPACE

Container No: S055428

Part: D2435
Job No: 173352-A
Serial No/Batch: S048556

Revision:
Inspector:

Date: 03/28/18

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

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DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>		APPROVED <i>KE</i>		REV. E	
DATE		TITLE		SHEET 1 OF 2	
98.05.19		BEARPAW		SCALE 1:5	
A	96.01.24	NEW ISSUE			
B	96.03.26	CHANGE BORE AND C'BORE DEPTH			
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED			
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)			
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50			



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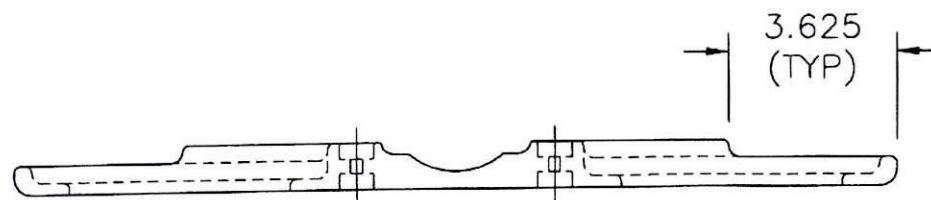
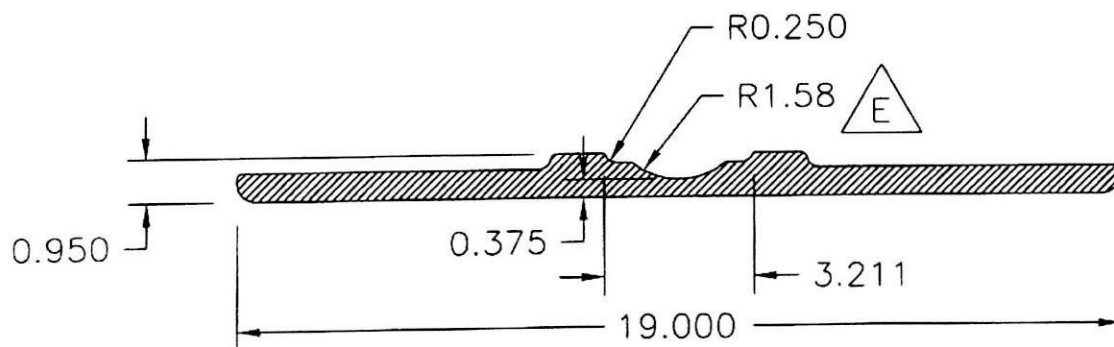
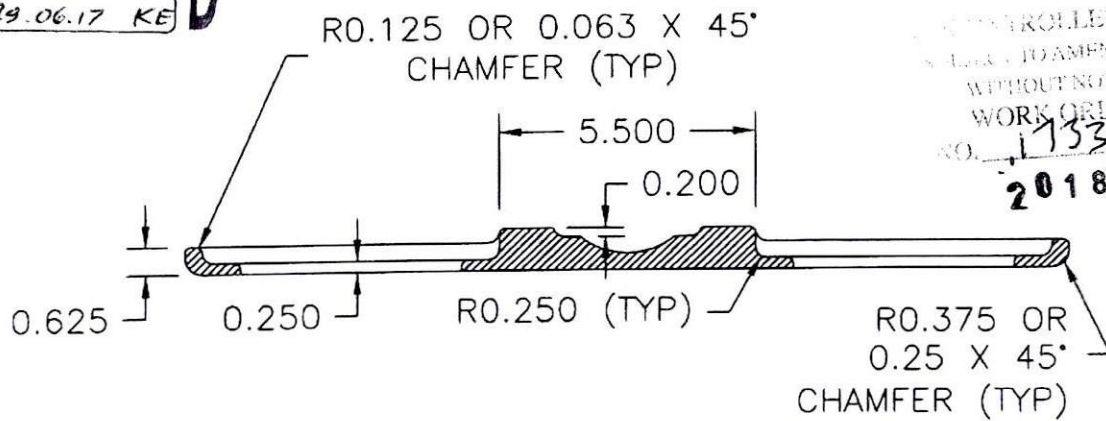
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689 2018030
1.00 THICK (MACHINE TO 0.950)

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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

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99.06.17 KE



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